

Date: Thursday, 12/7/2006 4:32:45 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 407 BASKET LID
<b>Job Number</b> : 29832B	
<b>Estimate Number</b> : 10917	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : D2952041
<b>This Issue</b> : 12/7/2006 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : D2952 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : <i>N/A</i> <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 21174B	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : <i>[Signature]</i>	<b>Due Date</b> : 12/19/2006 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>[Signature]</i> 061207	
<b>Comment</b> : Est Rev: C 03.11.26 Reformat KJ/RF	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6TS0750W062	6061-T6 SQ Tube.75x.062W



**Comment:** Qty.: 39.3750 f(s)/Unit Total : 39.3750 f(s)  
 Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 0.062" wall  
 (M6061T6TS0.750W.062)  
 Batch: *M9183*

*PD 06-12-14 (1)*

2.0	M5052H32S080	5052-H32 .080 Sheet
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**Comment:** Qty.: 0.0656 sf(s)/Unit Total : 0.0656 sf(s)  
 Material: 5052-H32/H34 (QQ-A-250/11 or QQ-A-250/8) 0.080"  
 (M5052H32S.080) or 6061T6S080 (M6061T6S080)  
 Batch: *M102723*  
 Identify as D2952-11

*PD 06-12-18 (1)*

3.0	D2953077	Spacer
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Pick:  
 Qty Part Number Description Batch  
 2 D2953-077 Spacer *522095*

*PD 06-12-18 (1)*

4.0	D2953175	Spacer
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Pick:  
 Qty Part Number Description Batch  
 1 D2953-175 Spacer *522096*

*PD 06-12-18 (1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: 407 BASKET LID

Job Number: 29832B

Part Number: D2952041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2957

Mounting Plate



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 D2957 Mounting Plate B21190

PD 06-12-18 (1)

6.0

M1100H14ES34X051F

Alum Expanded Metal



Comment: Qty.: 15.7500 sf(s)/Unit Total: 15.7500 sf(s)

Pick:

Qty Part Number Description Batch

15sf M1100H14ES-3/4x.051F Mesh 15444

PD 06-12-18 (1)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2952-11 corner gussets as per Dwg D2952

2-Drill holes in D2952-3 as per Dwg D2952.

3- Deburr & Remove any Markings From Material

4-Weld as per Dwg D2952 as per QSI 004. Deburr as required

A/R AL ROD Batch: M102421

PD 06-12-18 (1)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

12/06/12/19 (1)

9.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

12/06/12/19 (1)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PD 06-12-19 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/12/20

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: 407 BASKET LID

Job Number: 29832B

Part Number: D2952041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2983

Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Label Plate

B13263

ID 06-12-19 (1)

12.0

MS20600AD4W2

Rivet



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Rivet

M4747

ID 06-12-19 (1)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/12/19 (1)

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble Label Plate as per Dwg D2952

ID 06-12-19 (1)

15.0

POWDER COATING

POWDER COATING



M102391



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005.4.3

M.B./a.m.

06/12/19 (1)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAT 06-12-19 (1)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SA 06/12/19 (1)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/20

Job Completion



06/12/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

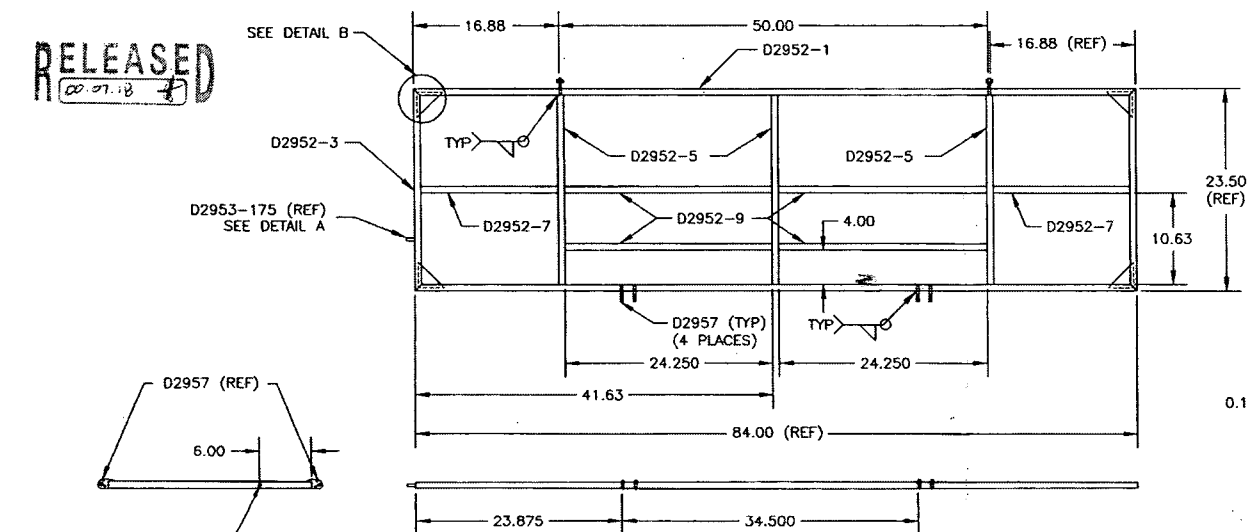
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

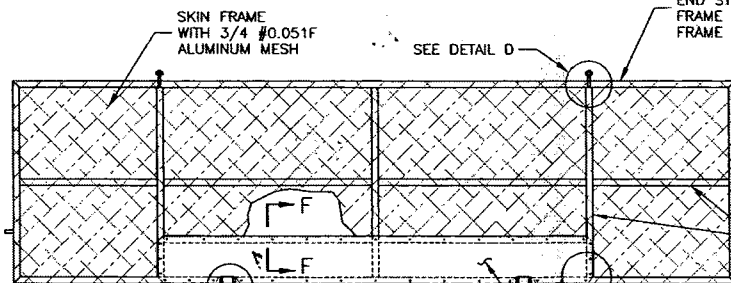
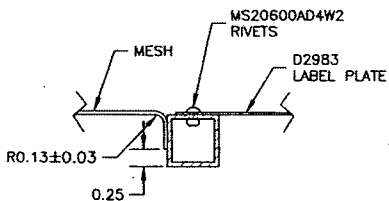
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED  
00-01-18

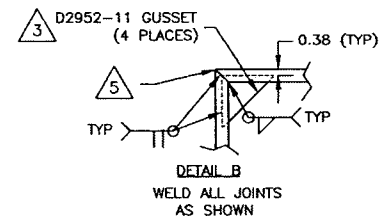
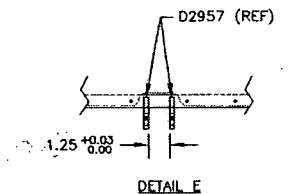
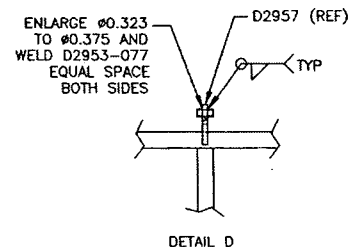
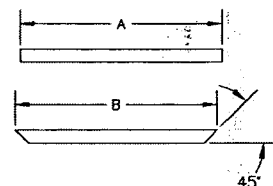
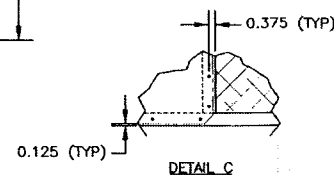
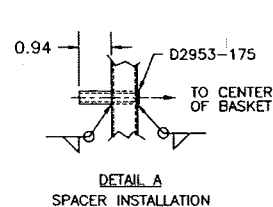


DRILL  $\phi 0.375$  HOLE  
AND INSTALL D2953-175  
SEE DETAIL A



TACK WELD EACH  
END STRAND TO  
FRAME ON OUTSIDE  
FRAME MEMBERS

TACK WELD EVERY  
2ND STRAND TO  
INTERNAL FRAME  
MEMBERS



# NOTES:

- 1) FRAME MATERIAL: 6061-T6, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING (QA-A-200/8 OR QA-A-225/9)
- 2) MESH MATERIAL: 5005-H34 OR 3003-H14 OR 1100-H14/H18 3/4  $\phi 0.051$
- 3) GUSSET MATERIAL: 6061-T6 (QQ-A-250/11) OR 5052-H32/H34 (QQ-A-250/8) (3.00 x 3.00) 0.080 THICK
- 4) WELD PER DART QSI 004
- 5) GRIND 0.063 MAX x 45° CHAMFER BEFORE WELDING CORNERS (TYP. 4 PLACES)
- 6) GRIND WELDS FLUSH ON TOP SIDE FOR LABEL PLATE, GRIND CORNER WELDS (4\*PLS) BOTTOM SIDE FOR GUSSET
- 7) TRANSFER D2983 LABEL PLATE HOLES USING  $\phi 0.128$  DRILL. INSTALL D2983 ONTO FRAME USING MS20600AD4W2 RIVETS (TYP. 34 PLACES)
- 8) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER  
NO. 248322  
UNCONTROLLED COPY  
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RETURN TO  
ENGINEERING  
SHOP COPY

QTY	PART NUMBER	DESCRIPTION	LENGTH A	LENGTH B
-041				
X	D2952-041	BASKET LID ASSEMBLY	N/A	N/A
2	D2952-1	FRAME MEMBER	N/A	84.00
2	D2952-3	FRAME MEMBER	N/A	23.50
3	D2952-5	FRAME MEMBER	22.00	N/A
2	D2952-7	FRAME MEMBER	15.88	N/A
4	D2952-9	FRAME MEMBER	24.25	N/A
4	D2952-11	GUSSET	N/A	N/A
1	D2953-175	SPACER	N/A	N/A
2	D2953-077	SPACER	N/A	N/A
6	D2957	MOUNTING PLATE	N/A	N/A
1	D2983	LABEL PLATE	N/A	N/A
34	MS20600AD4W2	RIVETS	N/A	N/A

B	00.07.06	CHANGE FROM SHEET TO MESH; ADD D2952-7/-9/-11
A	00.01.14	NEW ISSUE
DESIGN	RF	DRAWN BY RF
CHECKED	#	APPROVED
DATE	00.07.06	TITLE
		D2952
		BASKET LID ASSEMBLY

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**DART**

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HARRISBURG, ONTARIO, CANADA

REV. B  
SHEET 1 OF 1

SCALE  
NTS